

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020102**Date Inspected:** 03-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Fluxed Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Qui Wen.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3013-B 13AW

Weld No: 102, 108, 114, 120

Welder: 045280

WPS-B-T-2233-ESAB

Volts: 26.3

Amps: 261

PCMK: SEG-3013-P 13AW

Weld No: 092, 093, 096, 097

Welder: 045240

WPS-B-P-2132-ESAB

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Volts: 26
Amps: 251

PCMK: DP-3149-001 13CW
Weld No: 088, 089, 093, 094, 101, 102, 109
Welder: 207465
WPS-B-T-2232-ESAB
Volts: 26.3
Amps: 284

PCMK: DP-3133-001 13BW
Weld No: 018, 021
Welder: 204730
WPS-B-T-2232-ESAB
Volts: 26.1
Amps: 310

PCMK: DP-3133-001 13BW
Weld No: 024
Welder: 048433
WPS-B-T-2232-ESAB
Volts: 26.3
Amps: 302

PCMK: DP-3148-001 13CW
Weld No: 254, 257
Welder: 048696
WPS-B-T-2232-ESAB
Volts: 26.4
Amps: 316

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Qui Wen.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3013-B 13AW
Weld No: 126, 132, 138, 144, 150, 156, 162, 168, 174
Welder: 037723
WPS-B-P-2213-B-U2-FCM
Volts: 24
Amps: 150

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Photos please see ; Z:\Inspector Reports\B314 Rice

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
